

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009072**Date Inspected:** 19-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG & Tower Fabrication**Summary of Items Observed:**

CWI Inspectors: Mr. Zhu Tian Shu, Mr. Li Yang, Mr. Guo Yan Fei

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. This QA Inspector observed the following:

**OBG BAY 2**

This QA Inspector observed ZPMC welder Mr. Bi Laishu, stencil 045280 is using flux cored welding procedure specification WPS-B-T-2132-3 to make floor beam weld FB3083-003-010. The QA Inspector observed a welding current of 300 amps and 30.0 volts. Items observed by this QA Inspector appear to be progressing in compliance with project specifications.

This QA Inspector observed ZPMC welder Mr. Yan Shitan, stencil 062708 is using flux cored welding procedure specification WPS-B-T-2132-3-3 to make floor beam weld FB3083-003-022. The QA Inspector observed a welding current of 310 amps and 29.8 volts and that Mr. Yan Shitan is certified to make this weld. Items observed by this QA Inspector appear to be progressing in compliance with project specifications.

This QA Inspector observed ZPMC welder Mr. Lv Feng Yin, stencil 215676 is using flux cored welding procedure specification WPS-B-T-2132-3 to make floor beam weld FB3097-001-005. The QA Inspector observed ZPMC

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

Quality Control personnel monitoring this welding. This QA Inspector measured a welding current of approximately 280 amps and 30.0 volts. Items observed by this QA Inspector appear to be progressing in compliance with project specifications.

### OBG Bay 5

This QA Inspector observed ZPMC welder Ms. Gao Yulin, stencil 217805 is using flux cored welding process WPS-B-T-2133-B-U2-F to make traveler rail groove weld TR10-015-3. The QA Inspector observed a welding current of approximately 300 amps and 29.5 volts. This QA Inspector observed Ms. Gao Yulin is certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder stencil 215689 is using flux cored welding process WPS-B-T-2133-B-U2-F to make traveler rail groove weld TR10-015-4. The QA Inspector observed a welding current of approximately 300 amps and 30.0 volts. Items observed on this date appeared to generally comply with applicable contract documents.

### OBG Bay 9

This QA Inspector observed ZPMC welder Mr. Xiang Jie, stencil 059378 is using flux cored welding procedure WPS-B-T-2133 to make deck plate weld DP3029-001-130. This weld attaches a stiffener plate to the inside of closed rib for OBG deck panel DP3029-001. This QA Inspector observed the base material had been cleaned of oxides where the stiffener welds are to be installed. This QA Inspector observed a welding current of approximately 190 amps 24.6 volts and Mr. Xiang Jie is certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Xu Guo Yin, stencil 059443 is using flux cored welding procedure WPS-B-T-2133 to make deck plate weld DP3027-001-0267. This weld attaches a stiffener plate to the inside of closed rib for OBG deck panel DP3027-001. This QA Inspector observed the base material had been cleaned of oxides where the stiffener welds are to be installed. This QA Inspector observed a welding current of approximately 195 amps 27.0 volts and Mr. Xu Guo Yin is certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

See above.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 150-0042-2372 , who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Dawson,Paul	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

---